

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029002**Date Inspected:** 21-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Welder Wai Kit Lai #2953:

Welder was observed welding fillet welds and PJP welds for the OBG Retro Stiffeners at 13E PP119-ERS-1 thru 3.

The stiffeners mentioned above are the CCO 238 Retro Stiffeners to the "C" side plating. Welder was observed preheating and using Welding Procedure Specification (WPS) ABF-WPS-D15-F2200-2 for the fillet welds and ABF-WPS-D15-2170-3 for the 3G partial joint penetration or PJP welds. Welding parameters were verified by QC Inspector Fred Hays throughout the day and appear to be in compliance with the both WPSs noted above.

Welder Mike Jimenez #4671:

Welder was observed welding fillet welds and PJP welds for the OBG Retro Stiffeners at 13E PP119-ERS-16 thru 18. The stiffeners mentioned above are the CCO 238 Retro Stiffeners to the "C" side plating. Welder was observed preheating and using Welding Procedure Specification (WPS) ABF-WPS-D15-F2200-2 for the fillet welds and ABF-WPS-D15-2170-3 for the 3G partial joint penetration or PJP welds. Welding parameters were verified by QC Inspector Fred Hays throughout the day and appear to be in compliance with the both WPSs noted above.

Welder Richard Garcia #5892:

Welder was observed fitting the longitudinal deck stiffeners for deck access hole welds 14E PP2126.5 E2.0-LSE

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and LSW. Both fit ups were Visually inspected by this QAI and QC inspector Salvador Merino and were found to be acceptable. Welding was to commence after the midday break using Welding Procedure Specification (WPS) ABF-WPS-D15-1012-3. This QA was called to a different location on the bridge for the rest of the day and was unable to monitor or verify welding parameters.

Non-Destructive Testing (NDT)

This QA performed non-destructive testing on the following:

Weld 12W PP111.1 W2.1-LS3:

- o Hardness Testing (Faces A & B, 2 locations each)

Weld 14E PP126.5 E2.0-LSW:

- o Visual Testing Fit up Acceptable.

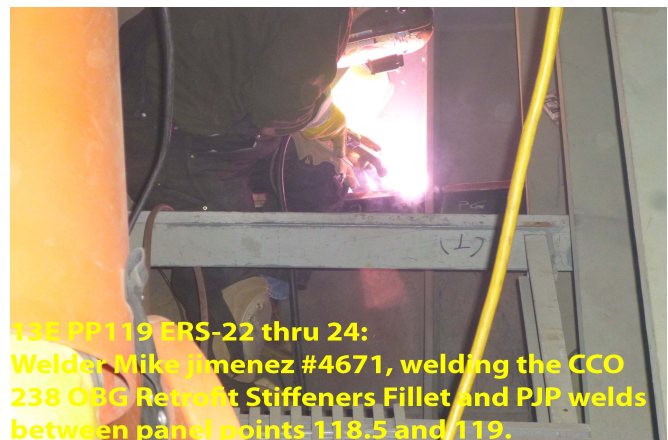
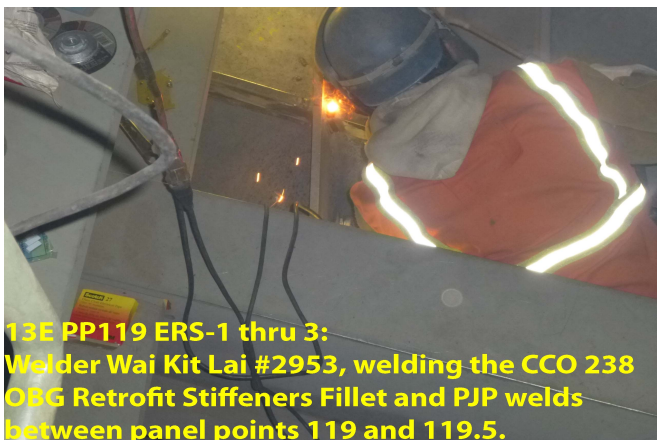
Weld 14E PP126.5 E2.0-LSE:

- o Visual Testing Fit up Acceptable.

Welds for CCO 238 OBG Retrofit Stiffeners (24 Stiffeners = 72 welds):

- o VT of multiple stiffeners rejected for excessive root opening. (Incident report submitted.)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents



Summary of Conversations:

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Conversations this day as required for scope of work.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

Inspected By:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer
